



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6510G05731-6F-2

Job Sheet 199047



Part No: RBW6510G05731-6F-2

Job Qty: 2 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/12/19

Job Tracking No:

Due Date: 10/21/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6510G05731-6F Rev A IPP Rev. A 19.08.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	NV5000 - 1	2 pcs	10/21/19		1.00	0.50	NV5000 - 1		
							NV5000 - 2		
110	QC 2	2 pcs	10/21/19		0.00	0.00	QC 2 - 1		ALA/KF 19-09-21 KF 19-09-21
							QC 2 - 12		
							QC 2 - 14		ALA/KF
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S215790



Part: RBW6510G05731-6F-2

Job No: 199047

Serial No/Batch: S215790

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 09/21/19

120 QC 8	2 pcs	10/21/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	A. 19-09-21
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
125 Outsource - 12 - Black Oxide	2 pcs	10/21/19		GRO002-VC	A. 2019-09-23
126 Packaging 2-1 - Receive - B4B	2 pcs	10/21/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	JP SEP 27 2019
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
127 QC 6	2 pcs	10/21/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	DAS 61 9-89
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
130 Packaging 3-1 - Stock - B4B	2 pcs	10/21/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
140 QC 21 - SA	2 pcs	10/21/19	0.00 0.00	QC 21 - SA - 21	DAS 21 9-89 OCT 07 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - 1-Machine as per folio FC 999 FOLIO REV: AA DWG REV: A 2-Deburr

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

125 - -Issue P/O: 44559 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type;

4140 -Certificate of Conformity is required

8/12/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

126 - (Receive & Inspect for Damage & Mat'l Certs) C of C required.

127 - QC6- All purchased or subcontracted products

130 - identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-B-2.500X3.000 S - 1.500 x 3.000	4140 Steel Bar 2.500 x 3.000 1.500 x 3.000	.5780 ft (.289 ea)	100-NV5000 - 1	S183010

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-NV5000 - 1	MT-4140-B- 2.500X3.000 S-1.500 x 3.000	1	2	0

Part Specifications

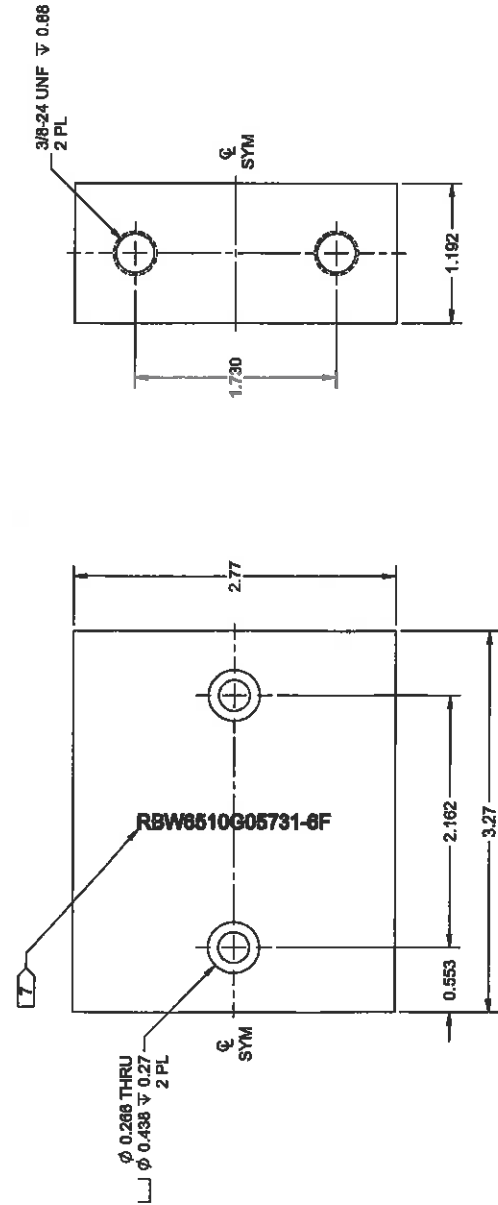
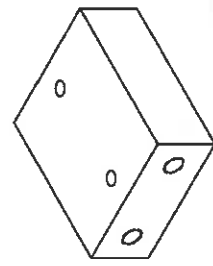
Specifications could not be found.

Plex 8/12/19 8:39 AM Dart.lajeunesse.marie

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

8 7 6 5 4 3 2 1



RBW6510G05731-6F-2 SUPPORT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 159087-M5
19-08-12

- NOTES:
- 1) MATERIAL: 4140 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81308 TYPE III
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 0.5"
 - X.XXX = +/- 0.005" / +/- 0.1"
 - X.XXXX = +/- 0.0005" / +/- 0.05"
 - PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK TIN "RBW6510G05731-6F", AS SHOWN

DESIGN	KPT	DART AEROSPACE LTD
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA
CHECKED	VM	TOOL PART #
MFG. APPR.	PK	RBW6510G05731-6F
APPROVED	WJ	TITLE
DATE	2019-07-09	SUPPORT BASE REM/INSTL. TOOL
		SCALE
		NTS
		SHEET 3 OF 5
		REV. A

PROPERTY OF DART AEROSPACE LTD
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UNCLASSIFIED DOCUMENT

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No.: _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐		Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐		Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐		Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐		Date : _____ Sequence #: _____ QTY Affected : _____ MRB (QS1042) _____			
Description Work Order Deviation				Disposition				Completed By							
Root Cause Operator ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ Material ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ Human Factors ☐ ☐ ☐				Pressure/Forced Bending ☐ ☐ ☐ Crushing ☐ ☐ ☐ Cracks ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ Mislabeled ☐ ☐ ☐				Contamination Misaligned/off center ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ Fit/Function ☐ ☐ ☐				Power Loss/Surge Folio/Program ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ Weld ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐			
				FAULT CATEGORY				Positioned Wrong ☐ ☐ ☐ ☐ ☐							
				Other/Details: _____				Outside Tolerance Drawing ☐ ☐ ☐ Finish ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ Misread ☐ ☐ ☐							
QC / QA Coordinator				Lead hand / Supervisor				Completed By							



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER

POHB044559



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044559

PO Date: 9/23/19

Due Date: 10/1/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-09-29

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	199047	RBW6510G05731-6F-2	Support -Issue P/O: -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed -		10/1/19	6 pcs	0 pcs	6 pcs	\$6.95/pcs	\$41.70
				X6						DAS 61 9-89	DP
						SEP 27 2019					
2	199141	RBW6522A00231-W142AJ-3T-5A	Insert (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed -		10/1/19	6 pcs	0 pcs	6 pcs	\$2.69/pcs	\$16.14
				X6							DP
						SEP 26 2019					



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PURCHASE ORDER

POHB044559



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	199037	RBW6510G04631-6F-6	Bracket -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed -		10/1/19	12 pcs	0 pcs	12 pcs	\$1.85/pcs	\$22.20
				X12							DP
						SEP 26 2019					
4	197520	RBE350A94-2706-00-01	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed -		10/1/19	50 pcs	0 pcs	50 pcs	\$2.50/pcs	\$125.00
				X50							DP
						SEP 26 2019					
5	199255	RBST4241-15	Locating Pin -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed -		10/1/19	12 pcs	0 pcs	12 pcs	\$1.23/pcs	\$14.76
				X12							DP
						SEP 27 2019					
Grand Total:										\$219.80	



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PURCHASE ORDER

POHB044559



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/24/19 12:55 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(022664-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

022664 - 1

RECEIVED

SEP 26 2019

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

DART AEROSPACE LTD.

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
26-Sep-2019		Jigar Patel				POHB044559			
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
1	RBW6510G05731-6F-2 Rev.	RBW6510G05731-6F-2 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MIL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	6	6	0	0	0	
2	RBW6522A00231-W142AJ-3T-5A Rev.	RBW6522A00231-W142AJ-3T-5A OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6	0	0	0	
3	RBW6510G04631-6F-6 Rev.	RBW6510G04631-6F-6 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MIL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	12	12	0	0	0	
4	RBE350A94-2706-00-01 Rev.	RBE350A94-2706-00-01 SAND BLAST ALL OVER OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	50	50	0	0	0	
5	RBST4241-15 Rev.	RBST4241-15 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MIL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	12	12	0	0	0	

DAS
61
9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.